

In re: Severance, Jr.  
Appl. No.: 09/772,652  
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a nozzle positioned proximate the front end of said holder and defining a nozzle chamber therebetween, said nozzle defining a central bore for discharging a primary flow of gas from the nozzle chamber toward a workpiece located adjacent the nozzle, and further defining a plurality of secondary openings positioned across the nozzle chamber from the side openings at the front end of the holder for creating a secondary flow of gas therethrough.

32. (New) An electrode according to Claim 31, further comprising a valve assembly located in the internal bore of the upper tubular member, said ball valve assembly capable of regulating the gas through the electrode.

33. (New) An electrode according to Claim 31, wherein the side openings in said holder are arranged to impart a swirling motion to the gas exiting the side openings.

34. (New) An electrode according to Claim 31, wherein the plurality of side openings defined by the holder are located at a position less than 1/2 the length of the holder along the longitudinal axis from the front face of the holder.

35. (New) An electrode according to Claim 31, wherein the holder includes a threaded portion for threadably securing the holder to the upper tubular member.